Select 70CRP

Description:

Select 70CRP is a carbon steel electrode for flux cored arc welding with external gas shielding. This electrode is designed for use with carbon dioxide shielding gas using gas flow rates of 35-50 cfh. **Select 70CRP** is designed for welding of structural plate with surface contaminants, such as rust and weldable primers. Due to the unique formulation, welds can be made on primer and rust with minimal porosity and/or blowholes. **Select 70CRP** an ideal choice for welding automatic or semi-automatic fillet welds on ship panels, barges, or any plate that has been coated with rust preventative primer or non-coated plate that has rusted.

Classifications & Approvals:

- E70T-1C per AWS A5.20, SFA 5.20
- ABS 2YSA

Advantages:

- Welds over plates coated with rust or weldable primers with minimal surface defects
- The smooth arc characteristics and minimal spatter using 100% CO_2 shielding gas
- Produces excellent slag removal while welding over rust and contaminants
- Excellent choice for mechanized or semi-automatic welding on ship panels, barges, or any plate that has been coated with rust preventative primer or non-coated plate that has rusted.

Typical Mechanical Properties:

	100CO_2
Ultimate Tensile Strength (psi)	76,500
Yield Strength (psi)	62,000
Percent Elongation	33
CVN (ft•lb ƒ) @ 0°F	27

Typical Deposit Composition (wt%):

Shielding Gas	C	Mn	Si	P	S	Ni
100 CO_2	.05	1.14	.50	.006	.010	0.37

Recommended Welding Parameter:

		Optimum			Range			
Diam.	Position	Amps	Volts	WFS	Amps	Volts	WFS(in/min)	ESO
3/32"	Flat	425	29	180	300-500	26-34	110-240	1-1¼"

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